

Tuesday, 11/29/2005 12:43:44 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPACER BLOCK		
Job Number	: 25004A		Part Number	: D3193041		
Estimate Number	: 10251		Drawing Number	: D3193 REV B C 06-09-22		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 11/29/2005	S.O. No. : N/A	Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 1/10/2006 Qty: 8 Um: Each		
Previous Run	: 24048A					
Written By						
Checked & Approved By						
Comment	: Est Rev:A New Issue 05-11-05		JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B2500X03500	6061-T6 Bar 2.5" x 3.5"
	Comment: Qty.: 0.5156 f(s)/Unit Total : 4.1244 f(s) Material: 6061-T6/T651 (QQ-A-225/8 or QQ-A-200/8) (M6061T6B2.500x03.500) Identify for D3193-1 1/8 2/8 Batch: 1118315, M17805	SA 05-12-21
2.0	BAND SAW	BAND SAW
	Comment: BAND SAW Cut blanks: 3.500" x 2.500" x 5.900" long Bar	SA 05-12-21
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
	Comment: HAAS CNC VERTICAL MACHINING #1	
	1-Machine as per Folio FA374 and Dwg D3193 Identify as D3193-1	
4.0	2-Deburr and Tumble	Second check 3-G 06/09/22 01/09/22 8
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	arm 06-09-26 8
5.0	HAND FINISHING	HAND FINISHING RESOURCE #1
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	arm 06-10-02 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/06/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/29/2005 12:43:44 PM
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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11/4/10/03 (8)

7.0 MS20426AD3~~5~~7

Rivet



Comment: Qty.: 16.0000 Each(s)/Unit Total : 128.0000 Each(s)

Pick: 8.0

Qty Part Number Description Batch

MS20426AD3~~5~~7 Rivet M14533

8.0

M17694 X

8.0 MS21073L4

NUTPLATE



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick: 4.0

Qty Part Number Description Batch

MS21073L4 Nut Plate M18728

11/4/10/03 (8)

9.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3193-041 as per Dwg D3193

SB 06/10/05

10.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(8) 06/10/10

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/06	12	permanent change Kit packed on D206-667011		06/06		L	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: SPACER BLOCK

Job Number: 25004A

Part Number: D3193041

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 AN46A Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick: Packing Kit

Qty Part Number

8 AN4-6A

Description

Batch

Bolt

14.0 AN47A Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick: Packing Kit

Qty Part Number

8 AN4-7A

Description

Batch

Bolt

15.0 AN960JD416 Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 128.0000 Each(s)

Pick: Packing Kit

Qty Part Number

16 AN960JD416

Description

Batch

Washer

16.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

17.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-011

Job Completion



11/29/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

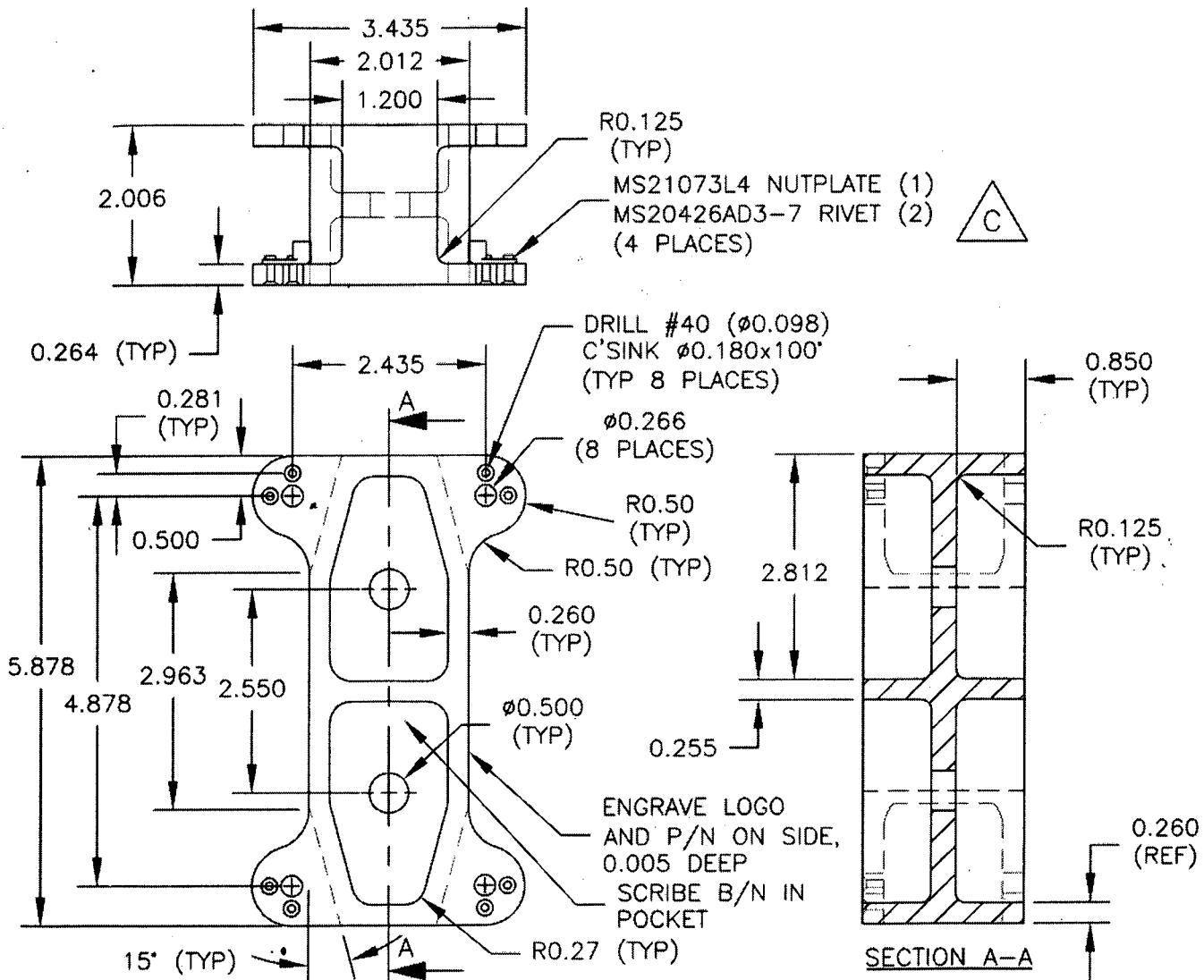
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>JF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>JF</i>	DRAWING NO. D3193	REV. C SHEET 1 OF 1
DATE 05.09.29		TITLE SUPPORT BRACKET ASSEMBLY	SCALE 1:2
A	03.06.09	NEW ISSUE	
B	03.12.22	MANUFACTURED BY DART	
C	05.09.29	MS20426AD3-7 WAS MS20426AD3-5	

RELEASED
05.09.29



D3193-041 SUPPORT BRACKET ASSEMBLY (D3193-1 SUPPORT BRACKET)

- 1) MATERIAL: 6061-T6 ALUMINUM (QQ-A-225/8 OR QQ-A-200/8)
(REF DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD	Work Order:	25004 A
Description: SPACER BLOCK	Part Number:	D3193-1
Inspection Dwg: D3193 Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X First Article  Prototype

Measured by:	<u>Arn</u>	Audited by:	<u>EJ</u>	Prototype Approval:	
Date:	06/09/22	Date:	06/09/22	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

5.0 PARTS LIST

Item	Qty -011	Qty -013	Qty -015	Qty -101	Qty -201	Qty -103	Qty -203	Qty -105	Qty -205	Part Number	Description
	X									D206-667-011	SPACER BLOCK KIT
	X									D206-667-013	NUT PLATE KIT (-101/-103/-105/-203/-205)
		X								D206-667-015	NUT PLATE KIT (-201)
			X							D206-667-101	CROSSTUBE INSTALLATION, 206A/B HIGH FWD
				X						D206-667-201	CROSSTUBE INSTALLATION, 206A/B HIGH AFT
					X					D206-667-103	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH FWD
						X				D206-667-203	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH AFT
							X			D407-667-105	CROSSTUBE INSTALLATION, 407 HIGH FWD
								X		D407-667-205	CROSSTUBE INSTALLATION, 407 HIGH AFT
1			1							D206-667-141	CROSSTUBE ASSEMBLY, 206A/B HIGH FWD
2				1						D206-667-241	CROSSTUBE ASSEMBLY, 206A/B HIGH AFT
3					1					D206-667-143	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH FWD
4						1				D206-667-243	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH AFT
5							1			D407-667-145	CROSSTUBE ASSEMBLY, 407 HIGH FWD
6								1		D407-667-245	CROSSTUBE ASSEMBLY, 407 HIGH AFT
10		*2	*2	*2			*2			D2891-1	SUPPORT
11							*2			D2892-1	SUPPORT
12								*1		D2894-1	SUPPORT
13		*2	*2	*2			*2			D2856-400-694	ABRASION STRIP
14							*2			D2856-400-773	ABRASION STRIP
15								*1		D2856-600-851	ABRASION STRIP
16		*4	*4	*4			*4			MS21920-20	CLAMP
17							*4			MS21920-22	CLAMP
18								*2		MS21920-24	CLAMP
19			4	4	4			4		AN5-32A	BOLT
20						4			4	AN5-34A	BOLT
21			4	4	4	4		4	4	MS21042L5	NUT (OR MS21042-5)
22			8	8	8	8		8	8	AN960JD516	WASHER
23									*2	D3190-1	CHAFING SHIELD
30	8									AN4-6A	BOLT
31	8									AN4-7A	BOLT
32	16									AN960JD416	WASHER
33	2									D3193-041	SPACER BLOCK ASSEMBLY
40	2		*2			*2	*2	*2	*2	D2873-043	NUT PLATE
41	2		*2			*2	*2	*2	*2	D2873-045	NUT PLATE
42		2		2						D2872-043	NUT PLATE
43		2		2						D2872-045	NUT PLATE
44	10		10		10		10			AN5-7A	BOLT
45	10	10		10			10	10	10	AN5-10A	BOLT
46	4	4	4	10	4			4		AN5-30A	BOLT
47	4							4		AN5-32A	BOLT
48	18	18	10	12	10	10		10	10	AN960JD516	WASHER
49	4	4			6					MS21042L5	NUT (OR MS21042-5)

*REFERENCE ONLY. PARTS ARE INCLUDED IN D206-667-141/241/143/243, & D407-667-145/245 ASSEMBLIES ABOVE

REFERENCE ONLY